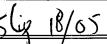
Qty:



Date:

Thursday, 5/10/2007 2:23:46 PM

User:

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

: GASKET

: D353625

: N/A

:NA

: 5/17/2007

· D3536 REV A

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 32271

Estimate Number

: 12719

P.O. Number

This Issue

:NIA

: 5/10/2007 : NC Prsht Rev.

First Issue

Previous Run Written By

Checked & Approved By

Comment

Type

: SMALL /MED FAB

S.O. No. : 1/1A

New Issue 07-02-14 JLM : Est Rev:A

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description: NEOPRENE SHEET 0.063

1.0

MNEO60S063

Comment: Qty.:

0.6254 sf(s)/Unit Total:

2.5015 sf(s)

NEOPRENE SHEET 0.063

M103104 Batch:

63/05/12

2.0

WATER JET



FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev:___

Prog Rev:__

GSD 0765/12

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SM

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1

5.0

Location:

PACKAGING RESOURCE #1

Identify and Stock

Comment: PACKAGING RESOURCE #1

Each

4 Um:

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE	By D	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		i								
		ı								
			Į.							
Part No	-		PAR #: Fault Category:	NCR: Yes No	DQA:	5 -	NOSH			

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA: Date: 07/05/14
	i		QA: N/C Closed: Date:

NCR:		· '	WORK ORD	ER NON-CONFORMANO	CE (NCR)		1	
	T	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		,					. !	
		!						
							!	
		!						
							İ	
		5						
				·				

NOTE: Date & initial all entries

,Date:

Thursday, 5/10/2007 2:23:46 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Part Number: D353625

Job Number: 32271

Seq. #:

Job Number:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospac	e Ltd		1	Í								
W/O:					1	W	ORK ORDER CHAN	GES					
DATE	STEP			;	PROC				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
				.	<u> </u>	······································				······			
				:									
					<u> </u>								
Part No):	<u> </u>		PAR #:	R #: Fault Category: NCR: Yes No DQA:		Date:						
									QA: N	I/C Close	d:	_ Date: _	
NCR:				1	W	ORK ORD	ER NON-CONFORM	IANCE	(NCF	₹)			
DATE			Description of NC			Corrective Action Section B			Verification		cation	Approval	Approval
DATE	STEP			Section A		Initial Chief Eng	Action Description Chief Eng		Sign 8 Date	Section C		Chief Eng	QC Inspecto
				1									
				!									
			<u> </u>	<u> </u>									
			† 	. !									
			1	!									
	:		i	I İ									
			1	<u> </u>									
]]											I

NOTE: Date & initial all entries

06.10.25

GASKET

 \rightarrow

06.10.25

NEW

ISSUE

CHECKED

Ŧ

D3536

SHEET 1 OF 6

SCALE 1:10

DRAWING NO

B

で到

DART

AEROSPACE PORT HADLOCK,

NC.

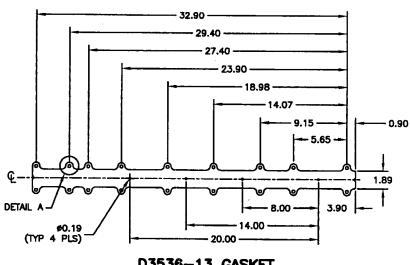
26.65	i
23.15	
21.15	
17.65	
13.40	
9.15	0.90
	`\
	1.89
DETAIL A 3.90 3.90	· '
(TYP 3 PLS) - 14.00	

D3536-11 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT SHOP COPY WITHOUT NOTICE ENGINEERING RETURN TO

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 7) SEE BACE & CONDITION AND OFFICEN

- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-13 GASKET

CHECKED

 \mathcal{Z}

D3536

SHEET

2 약 SCALE 1:10

DRAWING NO.

DART

AEROSPACE PORT HADLOCK,

≸

USA,

₹ ?

B

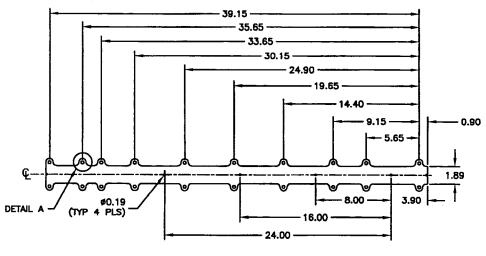


DATE

06.10.25

GASKET

O.O. IL TO CO.



D3536-15 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY ENGINEERING RETURN TO

봀

DOCUMENT

ខ

Copyright © 2006 by DART AEROSPACE USA, IN PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART.

, INC. NOT TO BE USED FOR ANY I NT AEROSPACE USA, INC.

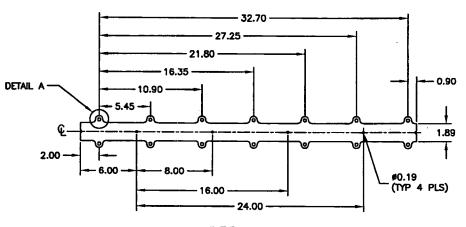
PURPOSE

욹

COPIED

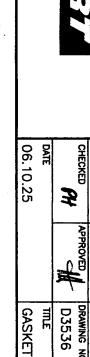
- MOTES

 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-21 GASKET



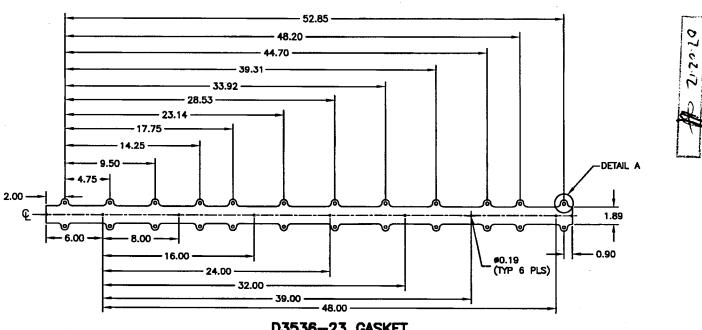




SHEET

3 약 SCALE 1:10

RC.



D3536-23 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDINENT WITHOUT NOTICE SHOP COPY ENGINEERING RETURN TO TONNAMA REPORTED

붚S

DOCUMENT

ᅜ

Copyright © 2006 by DART AEROSPACE USA, IN PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART.

INC.
NOT TO BE USED FOR ANY INC.

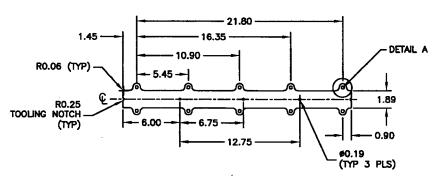
PURPOSE

욹

COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT €
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

CHECKED

 \mathcal{E}

D3536

면망

4 우 RP.

SCALE 1:10

DRAWING NO.

B

る。

DART

AEROSPACE

USA,

ਨ

PORT HADLOCK,

₹

DATE

06.10.25

GASKET

5(3) 5(4) 14(3) 14(3) 14(3)

07.02.12 21.00 2.00 -6.00 1.89 Ç. 6.00 DETAIL A #0.19 (TYP 3 PLS)

D3536-33 GASKET

22.50 19.00 2.00 ---9.50 6.00 Ç-1.89 DETAIL A 6.00 ≠0.19 (TYP 3 PLS)

D3536--31 GASKET



돺

DOCUMENT

ᄶ

COPYTIGHT © 2006 by DART AEROSPACE USA, IN PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART.

INC.

NOT TO BE USED FOR ANY I

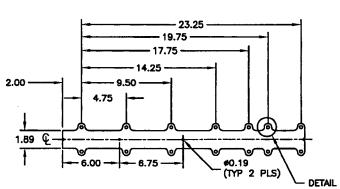
RT AEROSPACE USA, INC.

PURPOSE

윢

COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- FINISH: NONE
- 2) 3)
- PART IS SYMMETRICAL ABOUT ©
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
 IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



36-35 GASKET

23.25
19.75
17.75
14.25
2.00
4.75
1.89 €
6.00 - 6.75 - (TYP 2 PLS)
(TIP 2 PLS) \ DETAIL A

			D353

CHECKED

£

D3536

SHET

G SCALE 읶

1:10

DRAWING NO.

P

色 人 s

DART

AEROSPACE PORT HADLOCK,

USA,

₹ C.

06.10.25

GASKET

DATE

21.50.50

30.75 27.25 22.50 17.75 2.00 1.89 Ę 6.00 16.00 DETAIL A 21.00 #0.19 (TYP 4 PLS) D3536-37 GASKET

봀

DOCUMENT

 $\overline{\mathbf{v}}$

COPYTIGHT © 2006 BY DART AEROSPACE USA, IN PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART!

INC. OT TO BE USED FOR ANY IT AEROSPACE USA, INC.

PURPOSE

욹

COPIED

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TOLERANCES ARE PER DART US OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

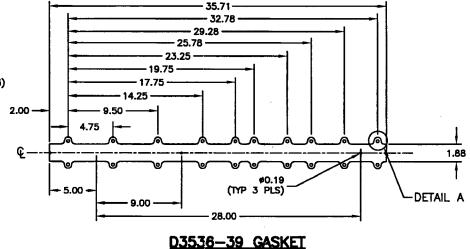
7) SEE PAGE 6 FOR DETAILS AND SECTION

SEE PAGE 6 FOR DETAILS AND SECTION

RETURN TO RETURN TO RETURN TO AMENDMENT

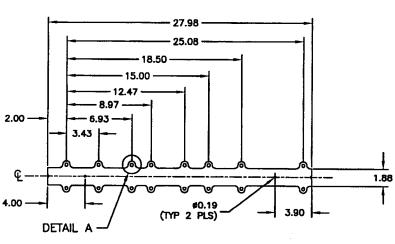
WORK OPDEN

WORK



DOCUMENT IS Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. **PURPOSE** 욹 COPIED



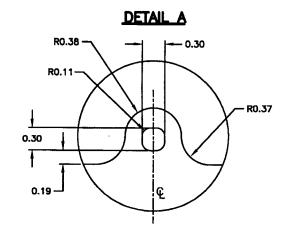
07:62.12

D3536-41 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY RETURN TO ENGINEERING



				-
1:10	GASKET		06.10.25	
SCALE	JULL 3		DATE	
SHEET 6 OF 6	D3536	#	W	
REV. A	DRAWING NO.	APPROVED //	CHECKED	
DART AEROSPACE USA, INC.	DART	CB	CB	

DART AEROSPACE LTD	Work Order:	32271
Description: Beampaw GASKET	Part Number:	D383626
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	spection Sheet wing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
А	21.80	+/- 0.030	21,81	V		the Mit	
В	16.35	+/-0.080	16.35			W-T	
С	10.90	+/. 0.030	12,90			M-T	
D	5,45	4/0.030	5.45			Vern	
E	1.45	460.030	1,45		,	Vern	
F	6.00	4-6.030	6.01			Vern	
G	6.75	1/- 0.030	6.74			Vern	
Н	12.75	460.030	15,74	<u></u>		Vern	
1	0.90	1/ 0.030	0.91			Veun/neig	ht says
J	1.89	1/0.030	1,89			Vern)	78
K	6.30	+1.0.030	0.30			Vern	
L	0.30	+/-0.030	0.31			ven	
M	80.19	t.0.030	\$0.200		,	Vern	
N							
0							
Р							
Q							
R							
S							
T.							
U							
V							
W							
Х							
Υ							

Measured by:	SAD	Audited by:	2/2	Prototype Approval:	N/A
Date:	07/05/12	Date:	07.05.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.01.09	New Issue	KJ/RF	